

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017721**Date Inspected:** 26-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

NDT

BAY 11

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as OBG Bike path plate. The weld designations reviewed are as follows.

BK004ASD1-017-001, 002, 003, 004, 022, 023, 024, 027

NDT Notification No-07115

This QA Inspector observed the following work in progress:

BAY 11: SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 041271, 040690 Perform Shielded Metal Arc Welding (SMAW) on Lift 5 Bracket stiffener. Joint identified as ND1-BRSA5-2-6A. ZPMC QC Identified as Zhao Mao Mao. The welding parameters as measured using QC's calibrated instrument appeared to

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be in general compliance with WPS-B-T-3212-Tc-U5b.

Repair welding SMAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040723 Perform Shielded Metal Arc Welding (SMAW) on Lift 5 Bracket stiffener. Joint identified as SD1-BRSA5-1-11A. ZPMC QC Identified as Zhao Mao Mao with Temporary welding repair report WRR-T-WR3732. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-485-SMAW-2G (2F) –Repair 1.

This QA Inspector observed ZPMC qualified welding personnel identified as 040704, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate. Joint identified as BK004A1-023-043. ZPMC CWI Identified as Yu Dong Ping. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-Tc-U4c-F.

BAY 10

OBG Bike path plate Repair welding FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 057180, 500363, Perform Flux Core Arc Welding (FCAW) on OBG bike path plate weld build up 5~6 mm on plate edge. Plate identified as BK004A-29-8A, 8C, 9A, 9C, 10A. ZPMC QC Identified as Lijun with welding repair report WRR-B-WR14881. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-3G (3F) Repair.

OBG Bike path plate Repair welding FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 053869, Perform Flux Core Arc Welding (FCAW) on OBG bike path. Joint identified as BK004A3-026-002, 008. ZPMC QC Identified as Lijun with Temporary welding repair report. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-FCAW-1G (1F) Repair-1.

Magnetic Particle Testing:

This QA Inspector observed ZPMC Magnetic Particle Testing Inspector, performed MT on OBG Bike path cover plate. Joint identified as BK004A6-027-029, 030, 041, 042.

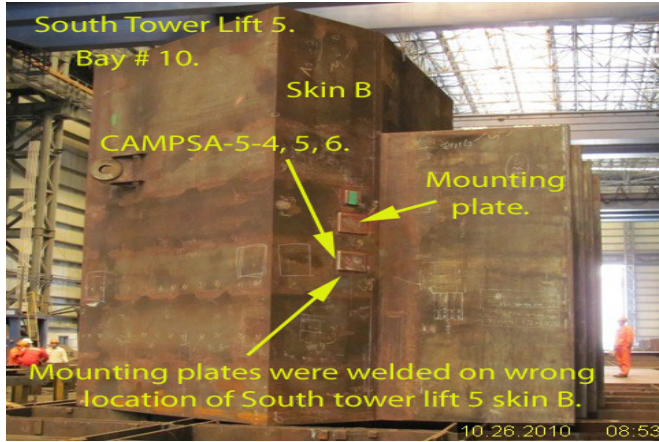
BAY 10:

During random visual inspection in Bay 10, this Quality Assurance Inspector (QA) discovered the following issue: Three (3) mounting plates were welded at wrong locations on South Tower, Lift 5, Skin 'B'. As per the approved shop drawing mounting plates should be on tower saddle grillage at approximately 159m elevation. These plates were located at approximately 150m elevation. The fillet welds are identified as CAMPSA-5-4, 5, 6. The member is located in Bay#10. For further information, please see the attached pictures. This QA Inspector generated incident report for this date.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho phone : 150002048250, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Shailesh

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer